



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

C3-18-9
Job Sheet 176624



Part No: C3-18-9

Job Qty: 4 ea

Part Name: Bumper



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/26/18

Job Tracking No:

Due Date: 4/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C3-18-9 Rev 3 IPP Rev A 18.03.19 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		4/30/18	0.00	0.00	Start Up Small Fab-4		FF
110	Small Fab	4 pcs		4/30/18	0.00	1.00	Small Fab-9		FF
130	QC	4 pcs		4/30/18	0.00	0.00	QC5		SB
140	Packaging	4 pcs		4/30/18	0.00	0.00	Packaging3-1		
150	QC21-SA	4 Ea		4/30/18	0.00	0.00	QC21		

Part Op
Descriptions: 110 - 1-Cut as per DWG. 2-Deburr

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
E3TZ-4730-A	Bumper	4 Ea (1 ea)	90-Start up Operation	5060999

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	E3TZ-4730-A	4	24	0

Part Specifications

Specifications could not be found.

Plex 4/26/18 1:09 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPO: _____
Part No. _____	
NCR No. _____	

Date : _____	Step #: _____
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Description Work Order Deviation

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DEPARTMENT/PROCESS



Container No: S065652
Part: C3-18-9
Job No: 176624
Serial No/Batch: S065652
Revision: 3
Inspector: _____

DART AEROSPACE
 1270 Aberdeen Street
 Hamilton, ON K8A 1K7
 TEL: 1 813 832-8200
 Email: sales@dartaero.com
 www.dartaerospace.com

ing _____
 ty _____
 er _____
 Approval _____
 ted By _____
 / Supervisor Verification _____

Date: 04/26/18

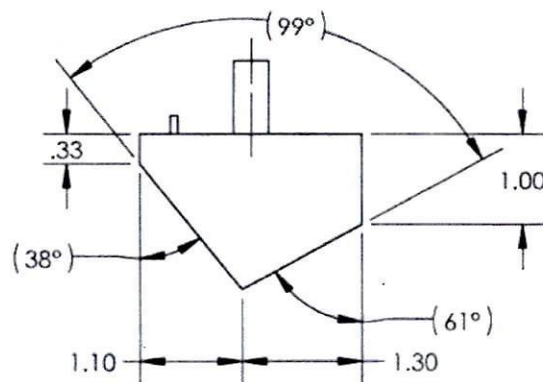
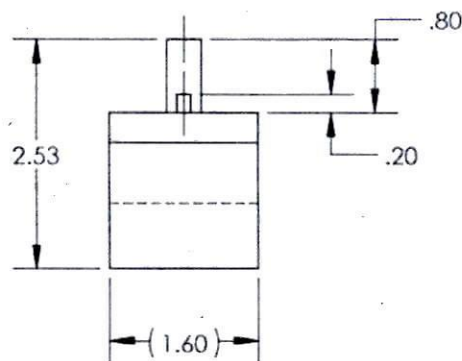
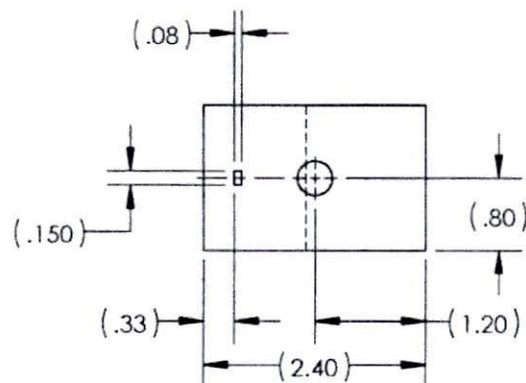
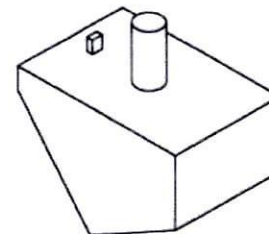
A Coordinator Approval

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0094	CH'D TITLEBLOCK DIMENSION TOLERANCES.	5/1/2015	RJC	JAG
3	16-0227	CH'D B/O REF WAS #E37Z-4730-A IS #E37Z-4730-A. CH'D DIMS WAS .08 IS (.08), WAS .150 IS (.150), WAS .80 IS (.80), WAS .33 IS (.33), WAS 1.20 IS (1.20), WAS 2.40 IS (2.40), WAS .20 IS (.20), WAS 1.60 IS (1.60), WAS 38° IS (38°), WAS 99° IS (99°), DELETED DIM 119°, ADDED DIM (61°), ADDED JIG NOTE.	11/21/2016	DPD	JAG

2.530
 .800
 1.730



- NOTES:
 1. FABRICATE FROM BUMPER E37Z-4730-A BY CUTTING.
 2. USE C45-15-10-F BUMPER CUTTING JIG.

DART AEROSPACE	
TITLE BUMPER	
DWG NO. C3-18-9	REV 3
MAT'L RUBBER FINISH SPEC DRAWN BY: CANAM CHECKED: <i>KG</i> 11/22/16 OPPTS APPR: <i>A.A.</i> QA APPR: <i>DP</i> APPROVED: <i>DP</i> 12/10/16 SCALE 1/2" = 1" DATE 6/3/2007	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .06 ANGLES ± 1° .X ± .1 SURFACES = 125° 1. BREAK ALL SHARP EDGES .015 ± .45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C3-18-9	1	BUMPER	RUBBER	(#E37Z-4730-A) MODIFIED